Work Orde		4177		*114	1177*							Page 1
Item ID:	D3560-043			Accept	*N900	0040	100)*	Setup	Start	*N!	S1 *
Revision ID: Item Name:	Arm Weldmer	nt								Stop	*N:	S2*
Start Date:	25/03/2014	Start Qty: 2.00	*2*		Cust Item	ID:						
Required Date:	25/03/2014	Req'd Qty: 2.00	*2*		Customer	:						
Reference:			,									
Approvals:	Process Pla	n:	Date: 14-03-5	Tooling:	I	Date:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	I	Date:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3560	Rev	D										
130		Pick Kit	2.0°	0.00		-						
130 Packaging		Мето		0.00								

Packaging

DQA:		Date:										
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UP		ork Order ug	odate only	AEROSPACE
or closed.		Dutc.								•		
Work Order:	:				DISPOSITION				AGAINST D	PARTMENT	/PROCESS	
					Rework			Skid-tube	Crosstube	1	Water Jet	Engineering
Part No					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No)				Suspected Unapproved	l		Large Fab	Composite	J	Supplier	
Root				Desci	ription of work order update	П	nitial	Acti	on	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design												
Doc/Data			<u> </u>			İ						
quip/Tooling	_]											
landling/Pre												
/laterial												
Operator	_											
Offset/Setup			,									
Process		1										
upplier												
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ransport	7											
Jnapproved		ļ										
						FA	ULT CA	regory				
Landing	Gear				General		,					
	Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
	Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	:i	Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		1	ions Incomplete/U	· –	Part Moved		Wrong Stock Pulled
	Crushing			Countersink	Г	4	ned/off center		Positioned V		_	
	Heat Treat			Cut Too Short		Mislabe			Power Loss/	_	Other	
	Inspection	n Strip in	Tube		Drawing	Г	Misread			-	·	
	Marks/Ch				Drill Holes		Off-set					,
	Turning So				Finish		4	Calibration				-
	Wave/Twist in Tube				Fit/Function		4	Sequence				 «·

March-04-14 2:	56:11 PM				F 1 7 7						
Item ID: Revision ID:	D3560-043			Accept	*N900	040	100)* s	etup Star	171	S1*
Item Name:	Arm Weldmen	t		•					Sto	ь жИ	S2*
Start Date:	25/03/2014	Start Qty: 2.00	*2*		Cust Item 1	D:					
Required Date:	25/03/2014	Req'd Qty: 2.00	*2*		Customer:						
Reference:			-						_		
Approvals:	Process Plan	n:	Date:	Tooling:	D:	ate:		R	un Sta	^ <i>V</i>	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:			Sto	_b *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		Large Feb		0.00							
140 Large Fab		Large Fab Memo		0.00					14.00	4-17	PD
Large Fab		STEP: 1- clean ma 2- set up br 3- preheat be 4- clean bei 5- set up m 6- weld acr 7- reheat w 8- on one s 9- same for	embly as per dwg D3560 aterial (buff bracket and boracket and arm on jig bracket and arm with torch fore welding with brush tachine to 135 amps ross bottom and top ends with torch (65 deg C) side weld from bottom to to r other side (half way) alf way point weld the rest	op half way	pedal near						
150 *150* oc		QC5- Inspect part comp	pleteness to step on W/O	0.00				2_		14.	Das 24 4-39-89
Quality Control		14161110									

JQA:		. Date:			WORK ORDER NOW	_							DART
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFOI	RMANCE / UP		Wd	ork Order up	odate only	AEROSPACE
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	•
Part N NCR N	0.				Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		Ĭ		Desc	ription of work order update		nitial	Actio	on		Sign &		
Cause	Date	Step	Qty		or non-conformance		ief Eng	Descri			Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
	- 6					FAI	ULT CA	EGORY					
Landin	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Unditions Incom			Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
ľ	Wave/Tw				Fit/Function		4	Sequence					

Work Order ID 114177

114177

Page 3 March-04-14 2:56:11 PM Item ID: D3560-043 Accept Setup Start *N900040100* **Revision ID: Item Name:** Arm Weldment **Start Date:** Start Qty: 2.00 25/03/2014 **Cust Item ID: Required Date: 25/03/2014 Reg'd Oty: 2.00 Customer:** Reference: Start Run Date: Process Plan: **Tooling: Approvals:** Date: Stop Date:_____ QC: ____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool# Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Code **Qty** Qty Number Stamp 160 QC9- Inspect visual per QSI004- Fusion Welds 0.00 DAS *160* OC 0.00 Memo **Quality Control** 170 Chemical Conversion Coat per QSI005 4.1 0.00 *170* HandFinish 0.00 Memo Hand Finishing 180 QC7-Inspect Chemical Conversion Coat 0.00 *120*

Quality Control

OC

Memo

0.00

DQA:	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Date:										
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order ug	odate only	AEROSPACE
Mark Ondon					DISPOSITION			AGAIN		PARTMENT		<u> </u>
Work Order:					0	1		المعددين المساولات		1	\4/-4 \-4\	7
Part No	J				Rework Scrap Use-as-is			Skid-tube Crosstul Machining Small Formation	ab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR No). 				Suspected Unapproved		mern	noforming Finishi Large Fab Composi		Rec/Stor	re/Packaging Supplier	Other
Root				Desci	ription of work order update	П	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	l	ief Eng	Description		Date	Verification	QC Inspector
Design								·				
Ooc/Data												
quip/Tooling												
landling/Pre		Ì										
Material												
Operator	1											
Offset/Setup										:		
Process	7											
iupplier												
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	·	····	1			FA	ULT CAT	EGORY				
Landing	Gear				General							, , , , , , , , , , , , , , , , , , , ,
	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concei	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	:ı	Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	⊢	Weld
	Crimp/Kink/Ripple/Wave Cuffs				Contamination	Г	1	ions Incomplete/Unclear		Part Moved	· -	Wrong Stock Pulled
	Crushing				Countersink	_	1	ned/off center		Positioned V		
	Heat Treat				Cut Too Short	-	Mislabe		<u> </u>	Power Loss/		Other
	Inspection Strip in Tube				Drawing	-	Misread		L.	J		1
-	Marks/Chatter				Drill Holes	\vdash	Off-set					
	Turning Sequence Finish						4	Calibration				
	Wave/Twist in Tube				Fit/Function	Г	4	Sequence		-		

Work Ord March-04-14 2.		4177		*114	177*						Page 4	
Item ID: Revision ID: Item Name:	D3560-043 Arm Weldmer	nt		Accept	*N900	040	100)* s	etup Start	171	S1* S2*	Ξ
Start Date: Required Date: Reference:	25/03/2014 25/03/2014	Start Qty: 2.00 Req'd Qty: 2.00	*9*		Cust Item I Customer:	D:						
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:	_	R	tun Start	^I <i>V</i> I	R1*	
	QC:	Bythe and add	Date:	SPC (Y/N):	Da	ate:			Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
1QO Small Fab		Small Fab Memo		0.00				2/			14/04/24	8
Small Fab		1-Press busi	ning in D3560 arm per dw	vg D3562							• •	
200 *200* QC Quality Control		QC5- Inspect part complete Memo	leteness to step on W/O	0.00 PAS 0.00 PAS 0.00 PAS 0.00 PAS	,			<u> </u>				

0.00

0.00

210

210
Packaging

Packaging

Identify as per dwg & Stock Location:

*** STOCK IN STEP CELL***

Memo

DAS 32 9-89

DQA:	WORK ORDER NON-CONFORMANCE / UPDATE										DART		
QA Closed:		Date:			WORK ORDER NON-	-((JNFUI	RIVIAINCE / U	PDATE	W	ork Order up	odate only	AEROSPACE
Mark Orda	\r•				DISPOSITION			**	AGAINST	DE	PARTMENT	/PROCESS	
Work Orde					Rework			Skid-tube	Crosstube	-]	Water Jet	Engineering
Part N	10				Scrap			Machining	Small Fab		1	d. Eng. Coor.	Quality
NCR N	lo				Use-as-is Suspected Unapproved		mem	noforming Large Fab	Finishing Composite	_	Rec/Stor	re/Packaging Supplier	Other
Root				Desci	ription of work order update		nitial	Ac	tion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
Design													
Doc/Data		İ	1										
Equip/Tooling													
Handling/Pre													
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Offset/Setup													
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Supplier						1							
Training						Ì							
Transport		į											
Unapproved													
				_		FA	ULT CA	TEGORY					
Landi	ng Gear				General		_				_		
	Bending				Bend		Folio/F	rogram			Outside Dim	ensions	Pressure/Forced
	Centre I	ot Conce	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorre	ci	Temperature/Cure
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/U	Inqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/	'Unclear		Part Moved		Wrong Stock Pulled
	Crushing				Countersink	П	Misalig	ned/off center			Positioned V	Vrong	-
	Heat Treat				Cut Too Short		Mislabe	eled		Γ	Power Loss/	Surge	Other
	Inspection Strip in Tube				Drawing		Misread	d		_	_		
	Marks/0	hatter			Drill Holes		Off-set						
	Turning	Sequence	!		Finish		Out of	Calibration					
	Wave/T	wist in Tu	be		Fit/Function		Out of	Sequence					

							·					
Work Orde March-04-14 2:		4177		*112	1177*							Page 5
Item ID: Revision ID: Item Name:	Revision ID: Item Name: Arm Weldment			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
		2		Cust Item II Customer:	D:							
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		nte:		:	Run	Start Stop		R1* R2*
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp

0.00

Memo

220

Quality Control

MH-25

DQA:		Date:										
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		ork Order up	odata aniv	AEROSPACE
Closed.		Date.				_				•		
Work Order	r:				DISPOSITION			A	AGAINST DE	PARTMENT,	PROCESS	
					Rework			Skid-tube Cr	rosstube		Water Jet	Engineering
Part No	o				Scrap			Machining Sr	mall Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	~ }	inishing	Rec/Stor	e/Packaging	Other
NCR No	0				Suspected Unapproved			Large Fab Co	mposite	j	Supplier	
Root	-			Desci	ription of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
Design						ļ						
Doc/Data												
quip/Tooling												
landling/Pre												
Material	_											
Operator	_											
Offset/Setup	_									i		
Process	_											
Supplier												
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Transport	_											
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Landing	_			_	General	_	1 .		_	1	_	_
_	Bending			-	Bend	╙	•	Program	<u> </u>	Outside Dim	—	Pressure/Forced
_	Centre No	ot Conce	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	_	Set-up
	Cracks			ļ	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred	<u> </u>	Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		1	ion Incomplete/Unquali	—	Part Lost/Mi	· -	Weld
	Cuffs			<u> </u>	Contamination		1	tions Incomplete/Unclea	ar	Part Moved	· · · · · · · · · · · · · · · · · · ·	Wrong Stock Pulled
	Crushing				Countersink	<u> </u>	1 7	gned/off center		Positioned W	_	
_	Heat Treat				Cut Too Short		Mislabe			Power Loss/S	Surge	Other
_	Inspection Strip in Tube			lacksquare	Drawing		Misread	d				
<u>L</u>	Marks/Ch				Drill Holes		Off-set					
<u> </u> _	Turning S	•			Finish		Out of (Calibration				
	Wave/Twist in Tube				Fit/Function		Out of	Sequence				

Picklist Print

March-04-14 2:56:10 PM

Work Order ID: 114177

114177

Parent Item:

D3560-043

D3560-043

Parent Item Name: Arm Weldment

Start Date: 25/03/2014

Required Date: 25/03/2014

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A

New Issue 07.05.24

ECN 987 07.10.09

EC EC

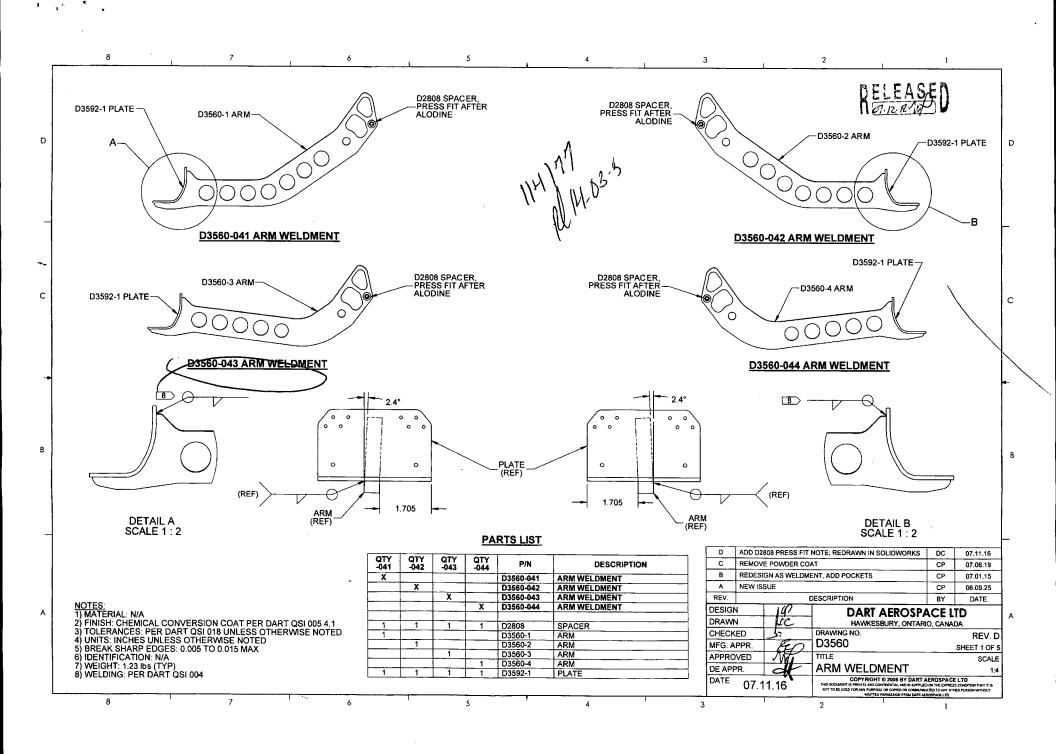
IPP Rev B IPP Rev:C

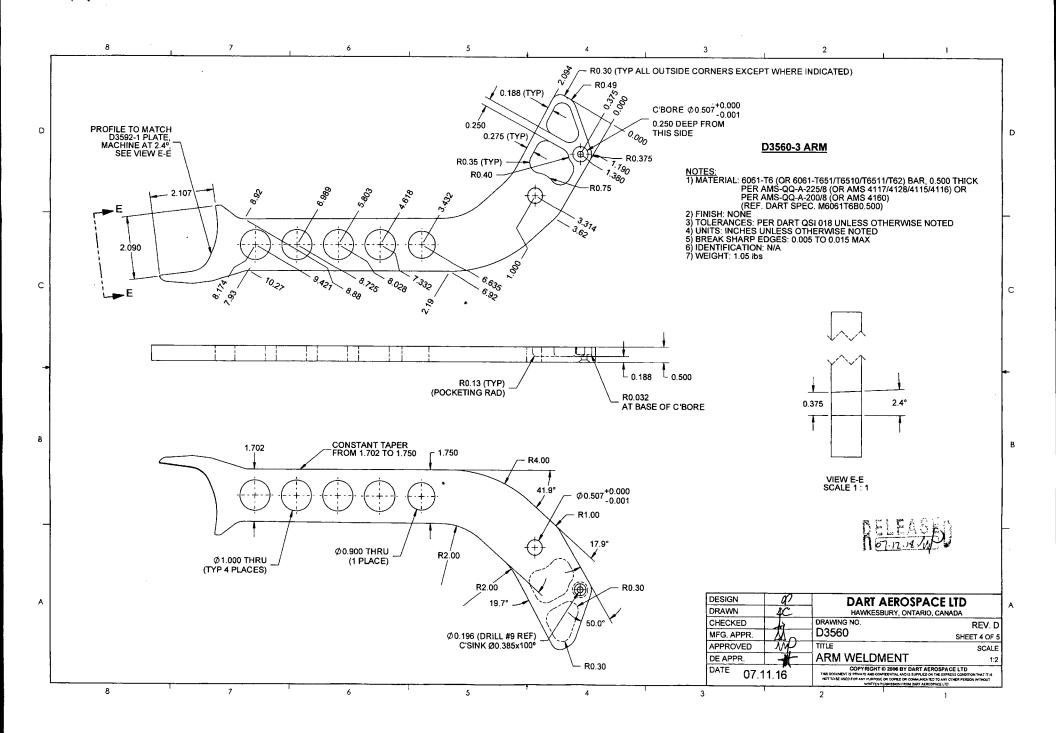
ECN1048 07-12-18

DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808		Manufactured	No				Each	106.0000		2		/	
D2808									**		14/04/	124	04 8 3 6 ² 89
				Location	<u>1</u>	Loc (<u>Oty</u>	Loc Code					-9
				GA			106				_		
					103647		10		_				
					108634		36		_	2			
					109348		60		_		_		
D3560-3		Manufactured	No				Each	5.0000		2			
D3560-3									**		②	14-6)U-1) {
				Location	<u>0</u>	Loc (<u>Oty</u>	Loc Code					
				WA003			5				_		
				+	107830		5			2	_		
D3592-1		Manufactured	No				Each	43.0000		2			
D3592-1	•								** _		(2)	14-0	417 P
				Locatio	<u>n</u>	Loc	Oty	Loc Code					
				WA003			43						
					106184		9		_		_		
					107722		34		_	(2)	_		

DQA:		Date:											
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	۱۸/	ork Order up	odata only	AEROSPACE	
QA Closeu.		Date.				_			VV	ork Order up	date only		
Work Orde	er:				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
					Rework			Skid-tube Crosstube	eГ]	Water Jet	Engineering	
Part N	lo.				Scrap			Machining Small Fal	b ──	Pro	d. Eng. Coor.	Quality	
					Use-as-is		Therr	noforming Finishin	g	1	re/Packaging	Other	
NCR N	lo				Suspected Unapproved			Large Fab Composite	e]	Supplier		
		_	,								·		
Root				Desc	ription of work order update	ı	Initial	Action		Sign &		ŀ	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design	_		Į.										
Doc/Data													
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Handling/Pre			1										
Material	_												
Operator	_												
Offset/Setup	_												
Process	_												
Supplier													
Training													
Transport	-					İ							
Unapproved				<u> </u>			III T CA	l ΓEGORY		<u> </u>			
Landii	ng Gear				General	FA	OLI CA	IEGONI					
Lanun	Bendin	o			Bend		leolio/s	Program	Г	Outside Dim	ensions [Pressure/Forced	
	_	⊳ Not Conce	ntric		BOM/Route		Grain	TOBIUM		Over/Under	 	Set-up	
	Cracks	rior conce	110110		Broken/Damage/Defect	┢	Hardwa	are		Part Incorred		Temperature/Cure	
		Kink/Ripple	e/Wave	-	Burrs		4	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	<u> </u>	Weld	
	Crimp/Kink/Ripple/Wave Cuffs			Contamination	_	1 '	tions Incomplete/Unclear	\vdash	Part Moved		Wrong Stock Pulled		
	Crushing			Countersink		- i	gned/off center		Positioned V				
	Heat Treat			Cut Too Short	\vdash	Mislabe		\vdash	Power Loss/	· ·	Other		
	Inspection Strip in Tube				Drawing	_	Misrea		L	,,	<u> </u>		
		Chatter			Drill Holes	厂	Off-set						
		g Sequence	•		Finish	Г	4	Calibration					
	Wave/Twist in Tube				Fit/Function		Out of:	Sequence					





DART AEROSPACE LTD 27/0042	Work Order:	13560-043K
Description: 31/4 for welling D3560-041 (043)	Part Number:	114177 14
o arm o		
Inspection Dwg: 3565 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.755	±.010"	1.705"	/		tape	
2.43	°ک. ځ	3.00	V		Protractor	
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·						
	D40					

	DAS		. /		
Measured by:	9 9- 8 9	Audited by:	5M7	Preliminary Approval:	
Date:	14.04.17	Date:	14/4/17	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15